

Date: Friday, 23/05/2008 9:54:52 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	LABEL	
Job Number :	39439			
Estimate Number :	10124			
P.O. Number :		Part Number :	D2258200	
This Issue :	23/05/2008	S.O. No. :		
Prsht Rev. :	NC	Drawing Number :	D2258 REV B1	
First Issue :	/ /	Project Number :	N/A	
Previous Run :	36848	Drawing Revision :	B1	
	Type :	Material :		
	PURCHASED PARTS	Due Date :	10/06/2008	Qty: 20 Um: Each
Written By :				
Checked & Approved By :	<u>JULIE 08.5.23</u>			
Comment :	Est: B 04.04.15 Reformat; Clarify Step 2 KJ/RF			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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**Comment:** PURCHASINGIssue P/O: 643608/05/23(20)

Make D2258-200 read 200lb / 91kg as per Dwg D2258

Material: Red letters (1.00" min height) with adhesive back Manufacture from 3M 7mil masking film #8522CP or Avery IPM #2031

Material release note is required

2.0	D2258200P	Weight Placard 200lb
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)
 WEIGHT PLACARD 200 LB

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Receive and Inspect for transit damage

Ensure material release note is attached

4.0	QC6	DIMENSIONAL CHECK
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**Comment:** DIMENSIONAL CHECK08/06/23 (20)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Identify and Stock

Location: ST2308/6/23 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 23/05/2008 9:54:52 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LABEL

Job Number: 39439

Part Number: D2258200

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/06/03

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



08/06/03

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries




DESIGN B WILLIAMS	DRAWN BY K HAND	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2258	REV. B SHEET 1 OF 1
DATE 95.11.29		TITLE UTILITY BASKET PLACKARD	SCALE 1:1
A	94.07.28	NEW ISSUE	
B	95.11.29	ADDED NOTE	
Bl	95.03.18	ADDED D2258-160	

RELEASED
99.10.12 KE

1" RED LETTERS ADHESIVE BACK

MAXIMUM DISTRIBUTED LOAD
XXX lb/ XXX kg

EXAMPLE

PART #	LOAD
D2258-132	132 lb/60 kg
D2258-200	200 lb/91 kg
D2258-220	220 lb/100 kg
 D2258-160	160 lb/73 kg

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 39439

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Scotchcal™

Opaque Imaging Media 8522

Description

This media is specially formulated to dry quickly after printing. Production of outdoor weatherable and long-term indoor durable graphics is now easier than ever. Its changeable adhesive allows easy removal for up to one year.

Advantages

- Optimized for use with selected Epson Stylus Pro printers and Epson Archival inks.
- Optimized for use with selected HP DesignJet Printers and HP DesignJet Ink System UV or HP83UV Color Ink System
- For making opaque, laminated graphics that are outdoor weatherable and long-term indoor durable
- Media:
 - For opaque (reflective) graphics
 - Changeable, easy to remove from warranted substrates up to 1 year later
 - Dries quickly after printing so the overlamine can be applied almost immediately
 - Low slippage paper liner for superior tiling
- Overlaminates:
 - Provide additional UV (ultraviolet) and physical protection for making weatherable finished graphics
 - Available in luster and matte gloss
 - Adhesive allows for heat-assisted or cold-temperature lamination

Applications and Uses

3M™ Scotchcal™ Changeable Opaque Imaging Media 8522 is intended only for ink jet printing and for use with the listed Compatible Products and Equipment and the following applications. Any other application is NOT warranted by 3M or covered by the worldwide 3M™ MCS™ Warranty unless 3M gives its prior written approval for the application.

- First surface images (the image is on top of the film) for opaque posters and signs, including:
 - Graphics for vans, personal vehicles, trucks and buses
 - Novelty posters
 - Retail and point-of-purchase displays
 - Information graphics such as maps and directories
 - Entertainment promotions in museums, zoos, parks, theatres, sports venues
 - Education and presentation graphics

- Legal and courtroom exhibits

- For flat or simple curved surfaces, with or without rivets, used in vertical ($\pm 10^\circ$) applications

Limitations of End Uses

The following uses and applications are specifically NOT warranted.

- Fleet applications in areas that use salt for winter road maintenance
- Application to non-warranted substrates, including wall-board
- Applications subjected to gasoline vapors or spills
- Application to corrugated or highly irregular surfaces or sharply raised areas
- Graphics applied to stainless steel, including stainless steel vehicles
- On flat surfaces with rivets, tenting of 4 to 10 mm around rivets may be expected; rivets may be cut around to eliminate tenting.

Note: Standard ink jet technology is water based. Water-based chemistry is susceptible to the extremes of heat and humidity. This is a factor in most product constructions on the market. Read the Fabrication, Shelf Life and Storage sections in this bulletin. Staying in the middle of these ranges always provides optimum performance.

Compatible Products and Equipment

Thermal Ink Jet Printing Systems

- Epson Stylus Pro 9500, Stylus Pro 10000 printer
 - Epson Archival Inks
- Epson Stylus Pro 10600 printer
 - Epson Archival Inks
- HP DesignJet Printers 2000 and 3000 series
 - HP DesignJet Ink System UV (pigment-based ink)
- HP DesignJet Printers 5000 series
 - HP83UV Color Ink System

Overlaminates (required)

- 3M™ Luster Overlamine 8519 (semi-gloss)
- 3M™ Matte Overlamine 8520

Note: For the full product names of the 3M products listed on this page, please see page 1.

Warranted Substrates

Media 8522 is warranted for use on the following rigid substrates.

Some substrates may "out-gas", resulting in tiny bubbles throughout the surface of the graphic. For maximum performance, be sure the substrate you select is properly cleaned and prepared as recommended by the manufacturer. See Instruction Bulletin 5.1 for additional information.

- Alodine (anodized aluminum)
- Automotive panels (automotive painted steel)
- Fruehauf (painted aluminum)
- FRP (fiberglass reinforced plywood)
- Glass
- Imron® (polyurethane-painted metal panel)
- Acrylic
- Sintra™ board

Test and Approve Non-warranted Substrates Before Use

Media 8522 is not warranted for any substrate other than those listed above. If you want to use it for other substrates, 3M recommends that you test and approve the media for both adhesion and removal characteristics.

Characteristics

Characteristic	Description
Media	7 mil, white, opaque graphic film
Liner	Low-slippage, lay flat paper
Adhesive	Changeable, pressure sensitive
Thickness (media and adhesive)	7.5 to 8 mil (nominal)
Application substrates	See Warranted Substrates, above
Application surfaces	Flat or simple curved surfaces, with or without rivets, used in vertical ($\pm 10^\circ$) applications (no corrugations)
Application temperature range	28° to 110°F (-2° to 43°C) (air and surface)
Roll sizes	36" x 45 feet (914 mm x 13.5 m) 54" x 45 feet (1372 mm x 13.5 m)

How to Become a 3M Ink Jet Registered Fabricator

Only 3M Thermal Ink Jet Registered Fabricators are eligible to offer 3M MCS warranted graphics. In order to become certified, a fabricator must complete the requirements as specified in the 3M Ink Jet Graphics Registered Fabricator Reference Manual located on the 3M website at www.scotchprint.com

Effective Performance Life

To obtain the warranty given below, the graphics must be made according to 3M's recommendations which are detailed in the Warranty and Limited Remedies on page 3. Also see the section, Removability.

Warranted Durability

Media 8522 with Overlaminate 8519 or 8520	Epson Printers		HP Printers	
	Outdoor	Indoor	Outdoor	Indoor
Applied to Warranted Substrates	2 years	5 years	3 years	5 years

Removability

Imaging media 8522 is removable from warranted substrates for 1 year without the aid of chemical strippers or accessories. Refer to Instruction Bulletin 4.23 for additional information.

Fabrication

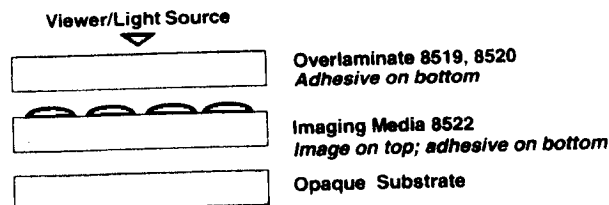
Graphics must be made according to 3M's recommendations which are detailed in the Warranty and Limited Remedies on page 3.

See Instruction Bulletin 4.23 for detailed fabrication, printing and mounting information.

Graphic Construction Options

Opaque (Reflective) Graphics

Opaque graphics made with imaging media 8522 require an overlaminate and an opaque substrate.





PRODUCT DATA BULLETIN

Product Data Bulletin: A5-O

Avery Graphics™ A5 Opaque
5-year **INTERMEDIATE** calendered vinyl film
Dated: 10/3/02

Description:

Avery Graphics™ A5 Opaque intermediate films are flexible, high-gloss calendered vinyls designed for use on computer sign cutting equipment. This construction provides excellent cutting, weeding and transferring characteristics for signage applications.

Application information can be found in the Avery Graphics Application Guide.

For surface preparation, converting and printing, and application and removal instructions, please refer to the Avery Graphics Instructional Bulletin.

Construction:

- Face Film: 3.2 mils opaque medium gloss intermediate calendered vinyl film
- Adhesive: 1.0 mil clear acrylic permanent solvent pressure-sensitive adhesive
- Liner: 78# bleached white kraft

Physical Properties:

The following information on physical and chemical characteristics is based upon tests believed to be reliable. The values are intended only as a source of information. They are given without guarantee and do not constitute a warranty. The purchaser should independently determine, prior to use, the suitability of this material for his/her specific purpose. (Data represents averages and is not intended for use as a specification).

- Outdoor durability: 5 years when properly processed and applied (vertical exposure, unprinted film)**
- Application surface contours: Flat and simple curves
- Minimum surface and air application temperature: +50° F (10° C)
- Service Temperature Range: -40° F to +180° F (-40° C to 82° C) (Reasonable range of temperatures which would be expected under normal environmental time and temperature conditions)
- Typical Chemical Resistance: Resistant to most mild acids, alkalis and salt solutions. See instructional bulletin for recommendations on cleaning.
- Shelf Life: One year when stored at the following temperatures and humidity conditions: 68°-77° F (20° - 25° C) and 50±5% R. H.
- Typical Adhesion Values: **180° Peels**

Substrate	24 hrs	1 week
Stainless Steel	4.4 lbs/in	5.1 lbs/in
Glass	4.7 lbs/in	5.3 lbs/in

NOTE: Tested per ASTM D 1000. Always pre-test your specific substrate prior to actual application.
- Reflectivity: NA
- Typical Gloss*: 70 at 60°

Avery Graphics™ A5 Opaque page 1 of 2
AnswerLine: 800-443-9380
Signage.averygraphics.com



210 MAIN W.,
HAWKESBURY, ONT. K6A 2H6
Tel.: 613 632-5449
Fax: 613 632-9491
www.studiolettrage.on.ca

INVOICE / FACTURE

VENDU À:
SOLD TO:

LIVRÉ À:
SHIPPED TO:

No.: 10351
DATE: 05/30/2003
PAGE 1 of 1
Re: Quote No. 5151

Dart Aerospace Ltd
1270 Aberdeen
Hawkesbury, Ontario K6A 1K7

Dart Aerospace Ltd
Hawkesbury, Ontario

ITEM ARTICLE	QTY QYE	UNIT UNITÉ	DESCRIPTION	GST TPS	PST TVP	UNIT PRICE PRIX UNITÉ	AMOUNT MONTANT
	20		D2258200P "maximum load cut vinyl"	G		5.00	00.00
	20		D33093P "grease" black on white	G		1.25	25.00
	2		set up	E		50.00	100.00
			E - GST @ 5%				
			G - GST @ 5%; PST @ 8%				
			GST				11.25
			PST Exempt: #6122-5207				
GST/TPS: R122278690							
TOTAL							236.25

PO 6436

Sold By:

Thank You!